

# Work Order ID 52871

October 16, 2009 10:07:34 AM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*BS*

Date: *09-10-16*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

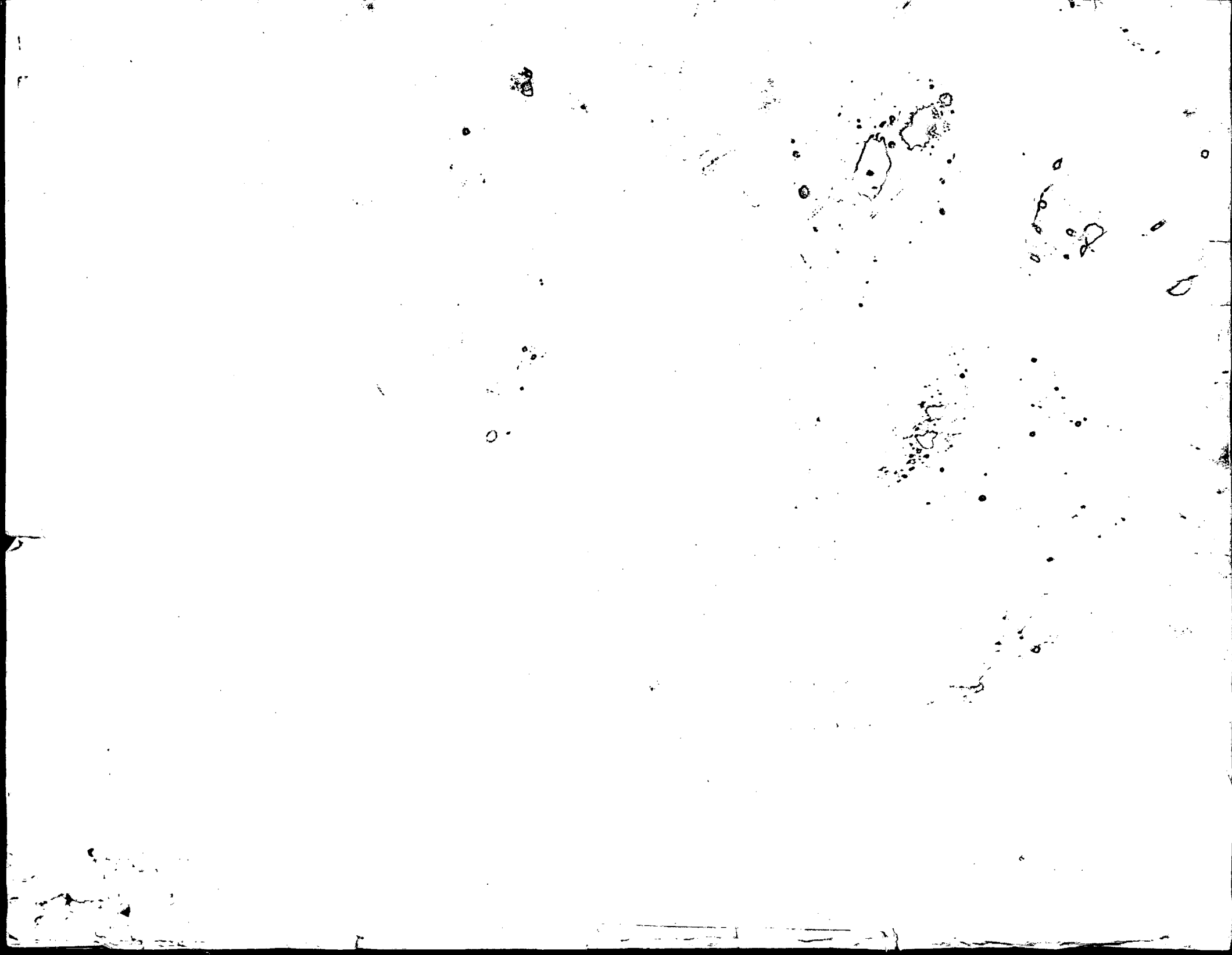
Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

*N/A*



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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	SAD 09-10-22						
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	2) S 09/10/26						
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	2) S 09/10/26						

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ M 11239 ☐

Sikaflex expire date: ☐ 10/12/30 ☐

Start: ☐ 9/10/28 ☐ Time: ☐ 1:15 ☐

Finish: ☐ 9/11/30 ☐ Time: ☐ 10:65 AM

(Adhere for 12 hours)

AWM 9-10-26

1 9/10/29

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) Seal 10/30

10

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Skidtubes

Skidtubes

0.00

0.00

Memo

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-IT2  
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT895 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

DP 9-11-2

1 11/11/2

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

258 occlulo3

0.00

Memo

h2 300'  
6' x 5'

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod M112507 *BE 09/11/04*

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

*10 9/11/04*

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

*2) 800000*

Quality Control

*(10)*

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210 QC10- Inspect visual per QSI004- ground welds

0.00



27 02/11/09

QC

Memo

0.00

Quality Control

220 Pressure Wash per QSI005 4.3

0.00



79 09/11/06

HandFinish

Memo

0.00

Hand Finishing

(X) 0

230 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M11248

ed 02/11/06

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:15 AM  
OVEN TEMPERATURE: 320°  
FINISH TIME: 9:45 AM

(X) 0



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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
250	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/R <input type="checkbox"/> N/A <input type="checkbox"/> LPS-3 <input type="checkbox"/> _____								
	2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> M112391 <input type="checkbox"/> _____ Sikaflex expire date: <input type="checkbox"/> 10/20								
260	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								

M/D 09/11/11

11

11

M/D 09/11/11

11/11

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

270

0.00



HAND FINISHING RESOURCE #1

HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☒ m112391

Sikaflex expire date: ☐ 10/20

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: \_\_\_\_\_

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☒ m112391

Sikaflex expire date: ☐ 10/20

US PROCYON BATCH: m104251

XI

WIP 09/11/11

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 \_\_\_\_\_

**Work Order ID 52871**

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Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

POP 52881

0.00

Packaging

PC 9/12/2 (C)

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03 (J)

MK  
09-12-02

# Picklist Print

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Page 1

12

Work Order ID: 52871



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2600-1-190RevD1 Manufactured No

110 Each 65.0000 1.0000



Extrusion Round 3" 206

DP 9-10-20

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

65

47575

65

110 Each 27.0000 1.0000

D3285-1RevA

Manufactured No



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

47635

27

150 Each 5.0000 1.0000

D3282-041RevC

Manufactured No



Float Web (206L/407)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

5

48389

5

B 52 696

1

1 AE 09-10-22

1 11 9/10/29

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Work Order ID: 52871

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	593.0000	20000			
Cross Bolt Spacer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	510	
36013	5	
47112	383	
48271	122	

D3275-1RevA1

Manufactured No

190

Each

28.0000

12.0000



Crossbolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	28	
47464	1	
48117	15	
48270	12	

Q 52510

12

BE 09/11/04

October 16, 2009 10:07:40 AM

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Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

CR3212-4-03 Purchased No 250 Each 310.0000 2.0000



Cherry Rivet

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	310	
	111359	96	
	112314	200	
	15984	14	

110139

X2 mtd 09/11/11

D3415-041RevB Manufactured No 250 Each 93.0000 1.0000



Nut Plate

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	93	
	33842	93	

X2 mtd 09/11/11

CCR264SS3-3 Purchased No 250 Each 267.0000 2.0000



Cherry Rivet

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	267	
	111548	52	
	111827	115	
	112314	100	

X2 mtd 09/11/11

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Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,373.000	78.0000			

Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5373

110511

5373

270

Each

41.0000

1.0000

X80 mtd 09/11/11

D3536-15RevA

Manufactured

No

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

47711

3

48159

12

51600

26

X1 mtd 09/11/11

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Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			270	Each	30.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51609	12	
Main Warehouse		
ST	18	
30754	1	
47713	17	

XI MD 09/11/11

D3536-35RevA

Manufactured No

270

Each

39.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	39	
48166	13	
51628	26	

XI MD 09/11/11



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Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-39RevA		Manufactured	No			270	Each	28.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51637	12	
Main Warehouse		
ST	16	
44648	1	
47714	4	
48161	11	

D3535-15RevB

Manufactured No



Wearshoe

270 Each 31.0000 1.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	18	
51671	18	
Main Warehouse		
ST	13	
30750	4	
42233	1	
48155	8	

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Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Ro-nt- Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	------------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-35RevB

Manufactured

No

270

Each

36.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

48157

10

51608

26

270

Each

26.0000

1.0000

D3535-39RevB

Manufactured

No



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

13

51619

13

Main Warehouse

ST

13

48158

13

X1 MD 09/11/11

X1 MD 09/11/11

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Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-23RevB		Manufactured	No			270	Each	24.0000	1.0000			



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	13	
(51618)	13	
Main Warehouse		
ST	11	
48156	11	

X1 MD 09/11/11

D3537-3RevC

Manufactured No

270

Each

69.0000

1.0000



Wearpad

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	69	
(30758)	7	
(33881)	17	
35697	45	

X1 MD 09/11/11

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Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			270	Each	284.0000	9.0000			

Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

265

51624

103

51678

162

Main Warehouse

ST

17

51918

17

AN960C10L

Purchased

No

270

Each

4,396.000 80.0000

washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4296

112116

993

112612

3303

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Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Big Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C416  washer		Purchased	No			270	Each	704.0000	1.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

704

100993

704

D3672-1RevB

Manufactured

No

270

Each

2,056.000 2.0000



Phenolic Washer

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1556

39275

19

42329

15

47628

522

52505

1000

Main Warehouse

ST117

500

51674

500

X1 MP 09/11/11

X2 MP 09/11/11

# Picklist Print

Page 11

October 16, 2009 10:07:41 AM

Work Order ID: 52871

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			270	Each	1,826.000	80.0000			

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

112314

112720

112724

112794

112829

1826

40

124

178

984

500

AL01 WMD 09/11/11

X19

AN4C5A



BOLT

Purchased

No

270

Each

601.0000 1.0000

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

104936

110552

112243

18918

601

19

80

500

2

X1 WMD 09/11/11

October 16, 2009 10:07:41 AM

Shop Packet Print

Page 11

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52871

**DART**

09-10-21

RELEASED

07.02.12

DEO ATTACHED

DESIGN <b>CP</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3274</b>	REV. D SHEET 1 OF 4
DATE <b>06.12.19</b>		TITLE <b>SKIDTUBE ASSEMBLY</b>	SCALE <b>NTS</b>
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

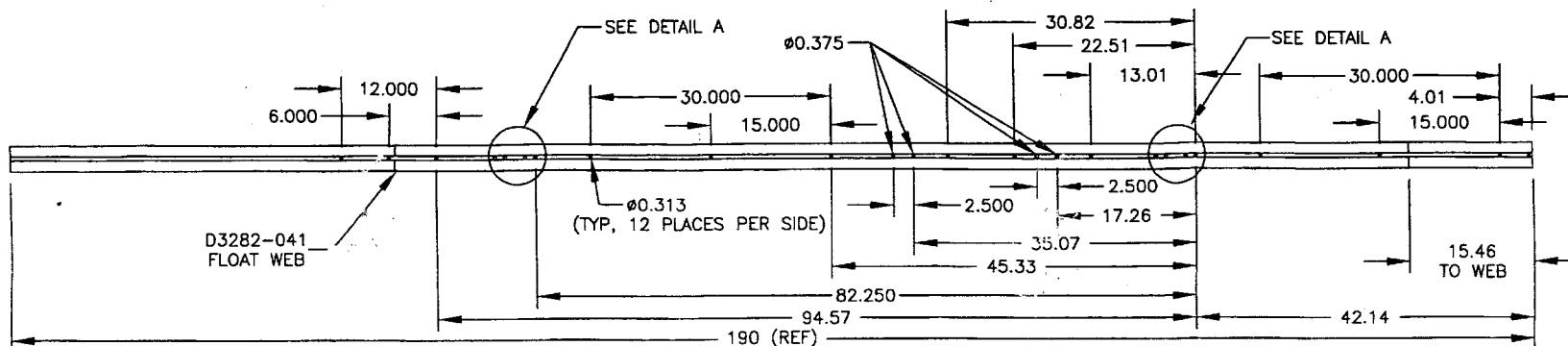
**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

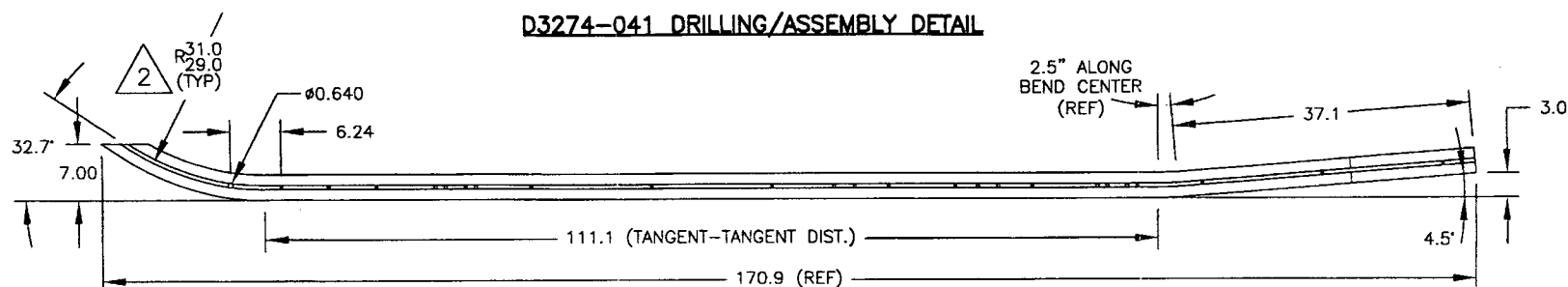
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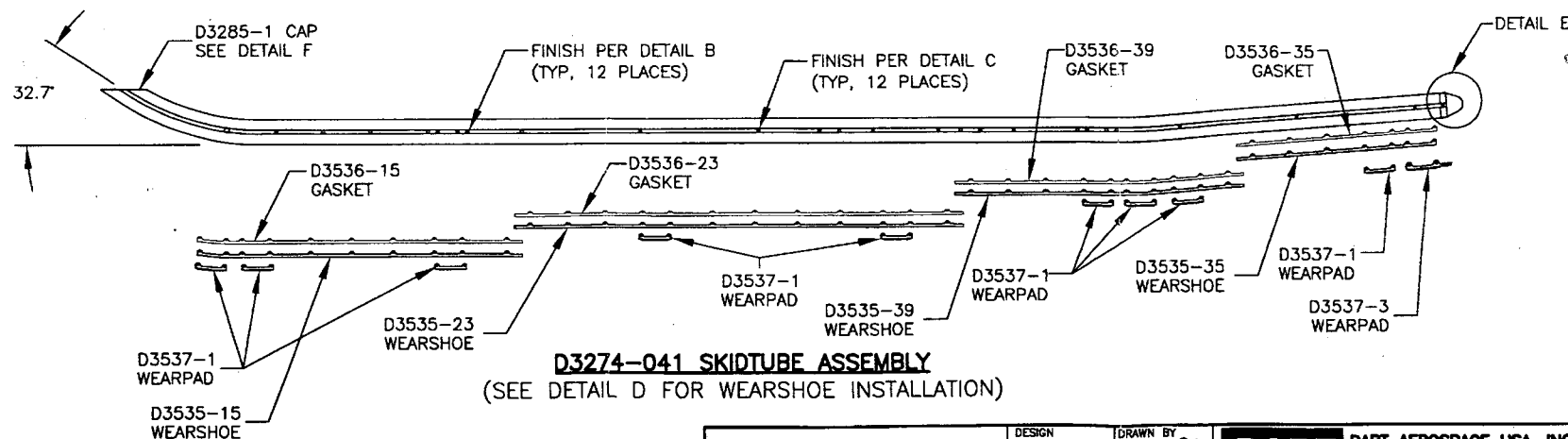
DEO ATTACHED



**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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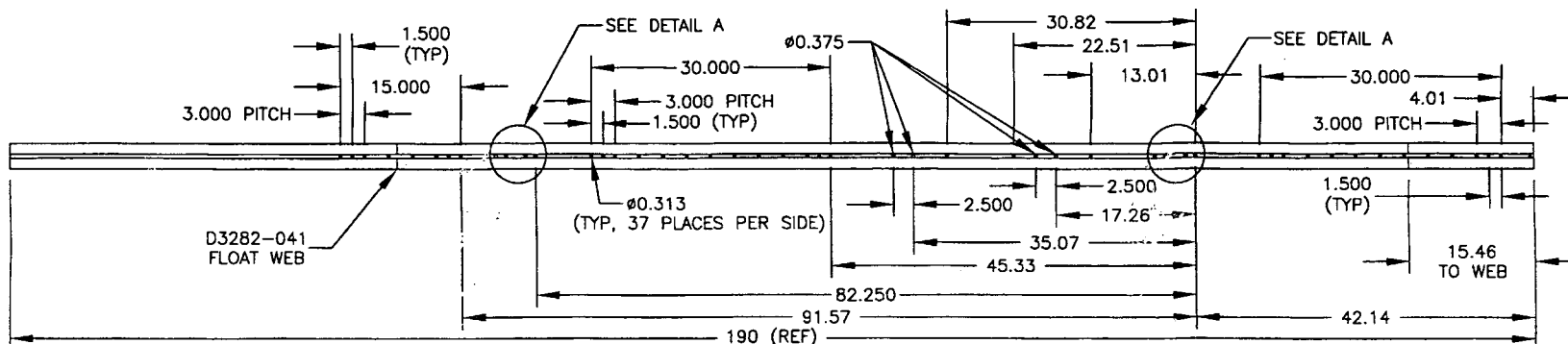
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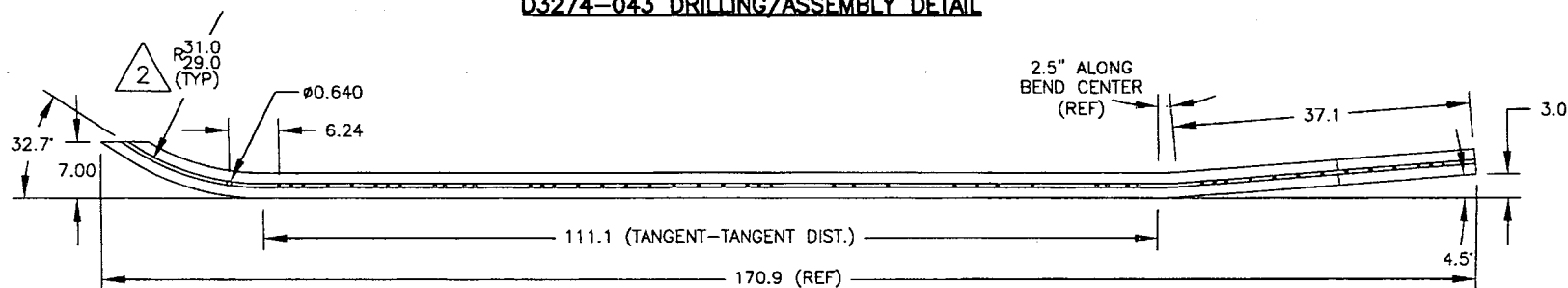
DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15



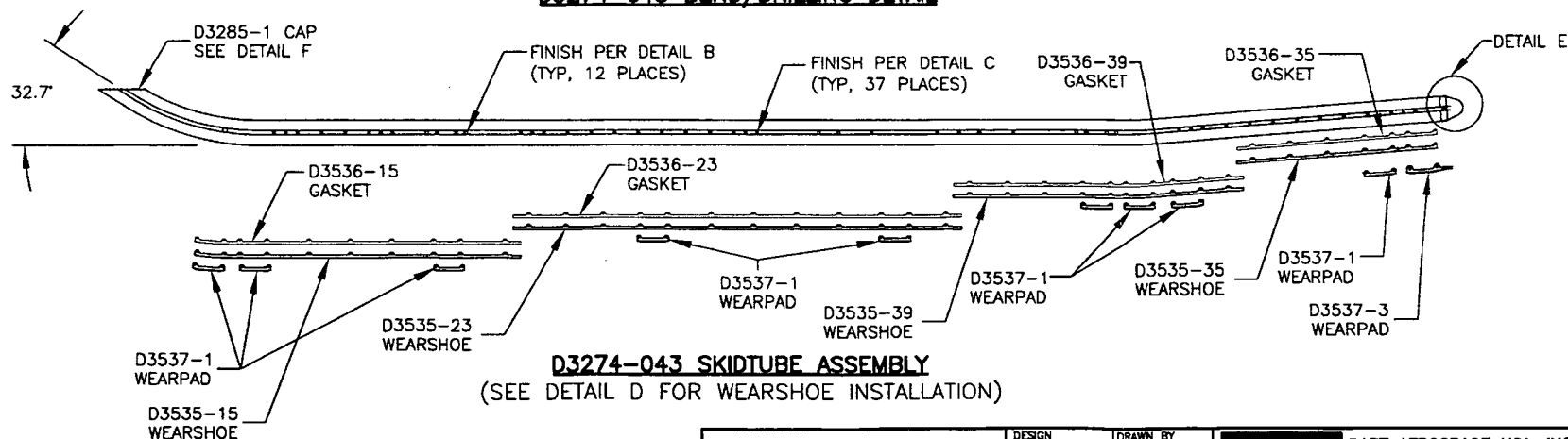
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**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY			SCALE 1:15

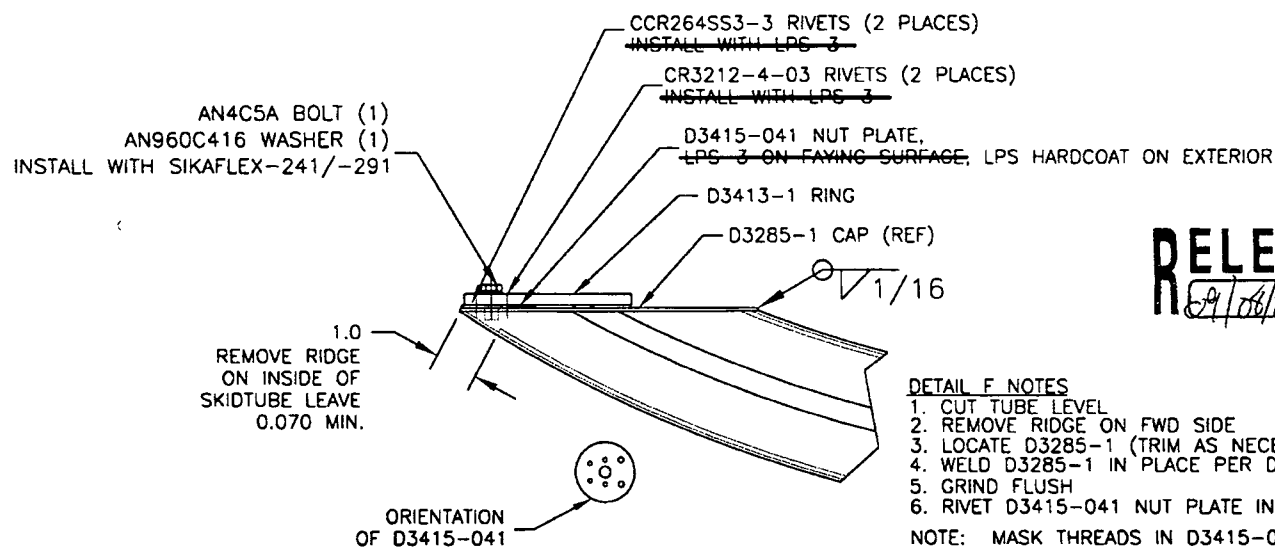
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 2: ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

*u/o 52871*

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NO. 214

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 52855  
Part number: D206-H42-251  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Dineen Date of Test Coupon 09.10.29  
Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

NO. 214

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 52855  
Part number: D206-442-251  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat. Dunn Date of Test Coupon 09.10.29  
Welder Barclay Elliott Date of Test Coupon 09.10.29

The above named individual is qualified in accordance with AWS D17.1.2001 to weld